

Work Order ID 62366

Tuesday, September 28, 2010 11:48:10 AM



Page 1

Item ID: PB67-43001-15

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 9/29/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 10-9-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001-15

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- make a 0.090" chamfer in the 1.00" hole before welding 2- assemble parts and weld as per dwg

PD 10.10.05 *1* *8*

110

0.00



QC

Memo

0.00

Quality Control

OK E QC9- Inspect visual per QSI004- Fusion Welds

PD 10.10.05

120

0.00



QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

N/A

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

105	Small Fab Large Fab	0.00							
	Memo	0.00							
	1- grind weld flush in area of PB67-43001-249 only								
	2- install helicol insert as per dwg								

10.10.05

140	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
	Quality Control								

8/10/06

150	Chemical Conversion Coat per SI005 4.1	0.00							
	Memo	0.00							
	Hand Finish								
	Hand Finishing								

N/A

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Item ID: PB67-43001-15

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Setup Start

Revision ID:

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Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 9/29/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/6/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

8/10/10/14



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: W/H

0.00

10/10/14



Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/15

MF
10-10-14

Picklist Print

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Work Order ID: 62366

Parent Item: PB67-43001-15

Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 9/29/2010

Required Date: 10/6/2010


Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
10.09.28 per rev C dwg EC verified by:DD


IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS124780  HELICAL INSERT		Purchased	No			180	Each	142.0000	1	1		10.10.05	
---	--	-----------	----	--	--	-----	------	----------	---	---	--	----------	--


Location	Loc Qty	Loc Code
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ST314	142	
111064	142	

MS27039-1-10  Screw		Purchased	No			180	Each	117.0000	8	8		10.10.14	
--	--	-----------	----	--	--	-----	------	----------	---	---	--	----------	--

Location	Loc Qty	Loc Code
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ST291	117	
112794	17	
112940	100	

NAS1149D0316J / AN960A5010LL  Washer		Purchased	No			180	Each	0.0000	8	8		10.10.14 B49600	
---	--	-----------	----	--	--	-----	------	--------	---	---	--	-----------------	--

NAS1149D0363J  Washer		Purchased	No			180	Each	2,907.000	8	8		10.10.14	
--	--	-----------	----	--	--	-----	------	-----------	---	---	--	----------	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST298	2907	
114292	114	
114884	41	
115107	27	
115622	2716	
9221	9	

Picklist Print

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Work Order ID: 62366

Parent Item: PB67-43001-15

Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 9/29/2010

Required Date: 10/6/2010

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-249 Manufactured No

100 Each

11.0000

1

1



Inner Tube Bushing



10.10.05

Location

Loc Qty

Loc Code

ST438

11

52480

11

PB67-43001-253 Manufactured No

100 Each

4.0000

1

1



Gusset



10.10.05

Location

Loc Qty

Loc Code

ST438

4

44983

4

PB67-43001-254 Manufactured No

100 Each

24.0000

1

1



Gusset



10.10.05

Location

Loc Qty

Loc Code

ST438

24

52481

24

PB67-43001-257 Manufactured No

100 Each

1.0000

1

1



Inner Tube



10.10.05

Location

Loc Qty

Loc Code

ST270

1

B 43070

62124

1

PB67-43001-71 Manufactured No

130 Each

3.0000

1

1



PB67-43001-71



10.10.05

Location

Loc Qty

Loc Code

ST437A

3

41512

3

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Shop Packet Print

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Picklist Print

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Parent Item: PB67-43001-15



Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 9/29/2010

Required Date: 10/6/2010

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-73

Manufactured No

180

Each

2.0000

1

1



20 Degree Cover Plate



10.10.14

Location

Loc Qty

Loc Code

ST445

2

41513

2

PB67-43001-83

Manufactured No

180

Each

6.0000

1

1



PB67-43001-83



10.10.14

Location

Loc Qty

Loc Code

ST445

6

52418

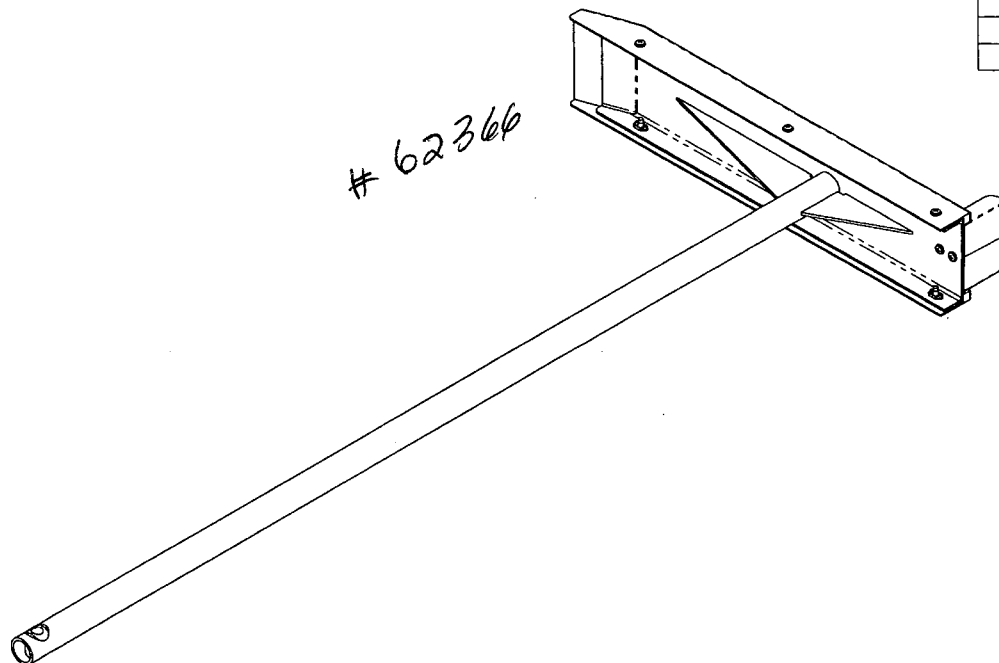
6

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Shop Packet Print

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62366



B67-43001-15 FWD ADJUSTABLE BLADE SUPPORT ASSY

ITEM	QTY -15	P/N	DESCRIPTION
1	X	B67-43001-15	FWD ADJUSTABLE BLADE SUPPORT ASSEMBLY
2	1	B67-43001-15W	FWD ADJUSTABLE BLADE SUPPORT WELDMENT
3	1	B67-43001-73	20" COVER PLATE
4	1	B67-43001-83	SHORT D-PAD ASSY
5	8	MS27039-1-10	SCREW
6	8	NAS1149D0316J	WASHER
7	6	NAS1149D0363J	WASHER

RELEASED
2010-09-16
MD

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 7 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	10.04.28
REV.	DESCRIPTION	BY	DATE
DESIGN	RW		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.	N/A		
DATE	10.04.28		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. C SHEET 1 OF 2	
DRAWING NO. B67-43001-15		TITLE FWD ADJUSTABLE BLADE SUPPORT ASSY NTS	
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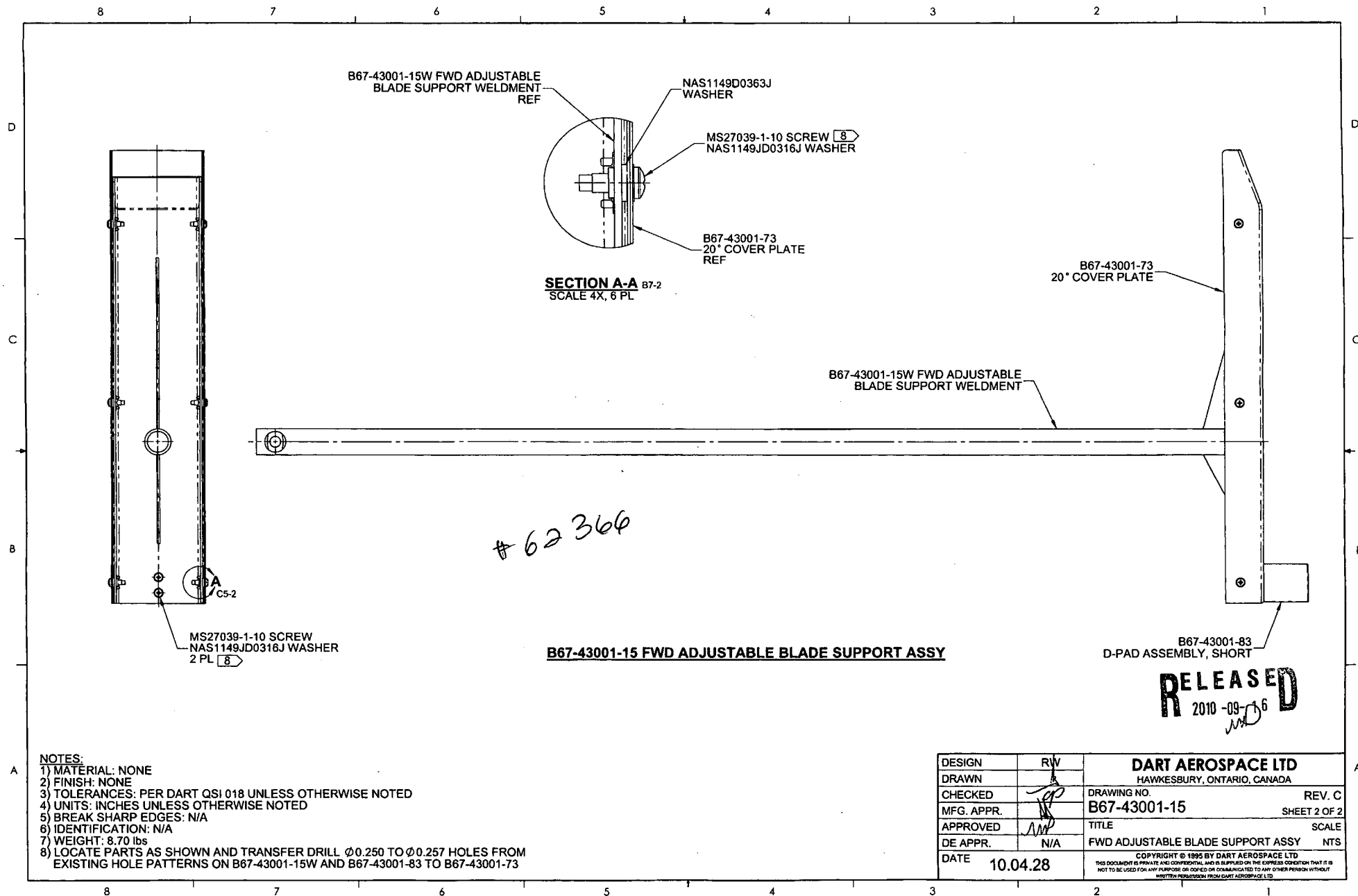
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

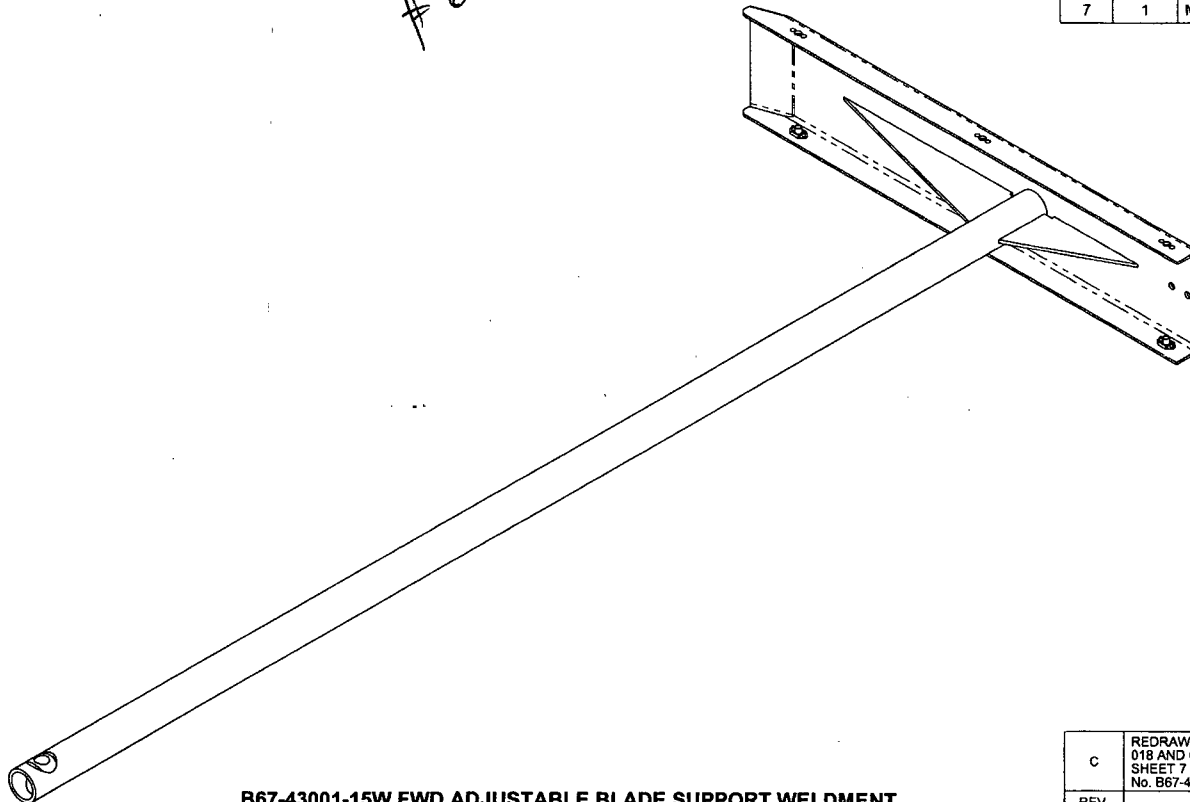
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

6 2360



B67-43001-15W FWD ADJUSTABLE BLADE SUPPORT WELDMENT

ITEM	QTY -15W	P/N	DESCRIPTION
1	X	B67-43001-15W	FWD ADJUSTABLE BLADE SUPPORT WELDMENT
2	1	B67-43001-71	20-DEGREE BLADE SUPPORT ASSY
3	1	B67-43001-249	INNER TUBE BUSHING
4	1	B67-43001-253	GUSSET
5	1	B67-43001-254	GUSSET
6	1	B67-43001-257	INNER TUBE
7	1	MS124780	HELICAL INSERT

RELEASED
2010-09-16

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 7 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION		BY	DATE
DESIGN	R/W	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-15W REV. C SHEET 1 OF 2 TITLE FWD ADJUSTABLE BLADE SUPPORT WELDMENT NTS DATE 10.04.28 <small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.	N/A			

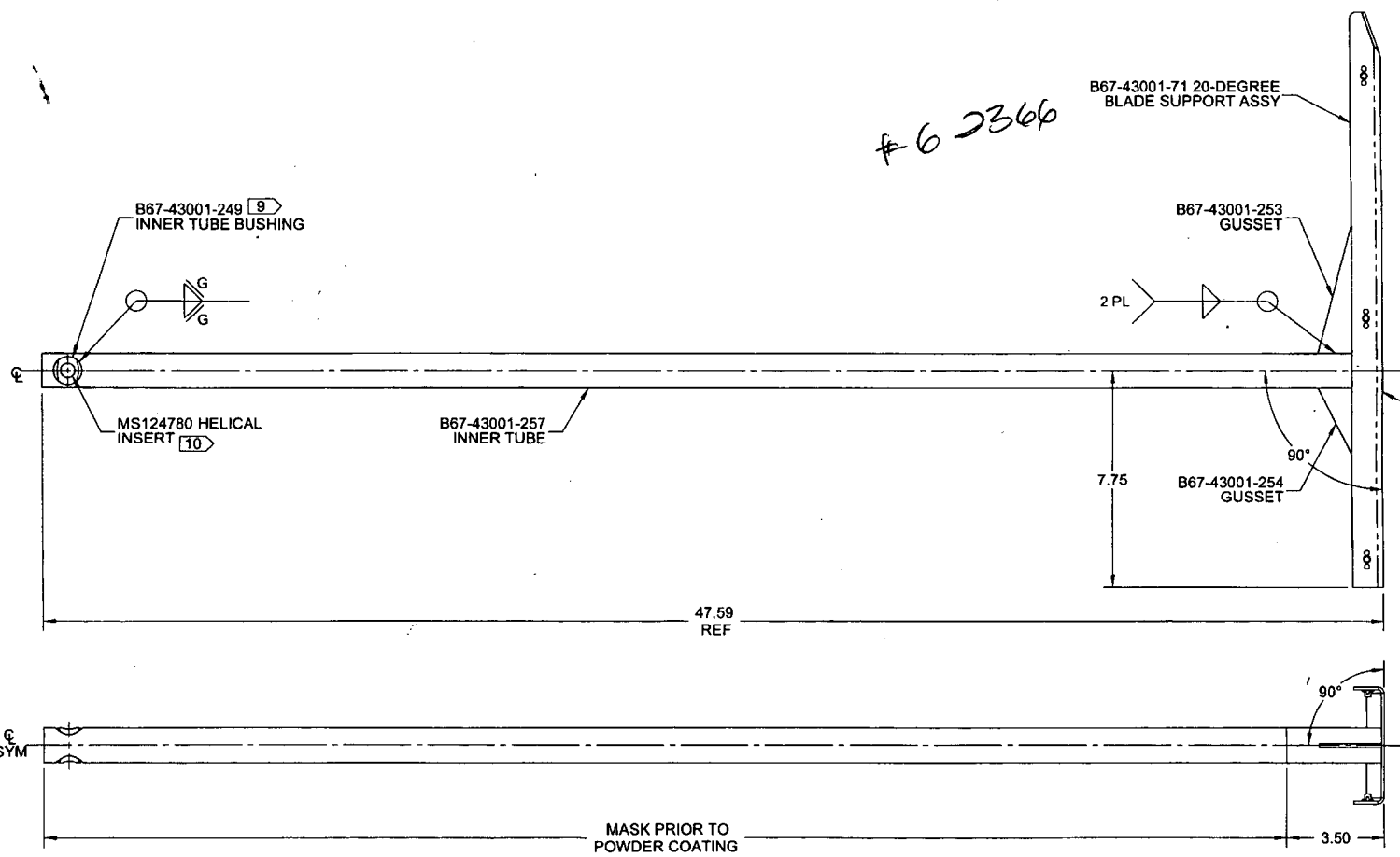
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



B67-43001-15W FWD ADJUSTABLE BLADE SUPPORT WELDMENT

- NOTES:**
- 1) MATERIAL: NONE
 - 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-15W" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 3.35 lbs
 - 8) WELDING: PER QSI 004
 - 9) GRIND B67-43001-249 BUSHING AND WELD TO CONTOUR OF TUBE IN ACCORDANCE WITH NOTE 8
 - 10) INSTALL HELICAL INSERT PER MS33537

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-15W	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	FWD ADJUSTABLE BLADE SUPPORT WELDMENT	NTS
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RELEASED
2010-09-16

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NOTE: Date & initial all entries